



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2596**Job Sheet 209888****Part No:** D2596**Job Qty:** 4 pcs**Part Name:** Web, 205 Skidtube**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 5/13/20**Job Tracking No:****Due Date:** 6/12/20**Created By:** Marie Lajeunesse**Type:** Stock**Description:** SIOP

Note: DWG REV D IPP: D 99.02.02 Changed QA to QC, Added Step 6 and Cost DM IPP Rev:E 07-07-09
Incorporated DEO 9183 JLM

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Skidtubes - 1	4 pcs	6/11/20		0.00	2.48	Skidtubes - 1		DJP 20-05-19
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
110	Handfinish - 1-1 Chemical-B4B	4 pcs	6/12/20		0.00	0.67	Handfinish - 1 - 1 - B4B		BFB 20-05-19
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		
							Handfinish - 1 - 4 - B4B		
							Handfinish - 1 - 5 - B4B		
							Handfinish - 1 - 6 - B4B		
							Handfinish - 1 - 7 - B4B		
							Handfinish - 1 - 8 - B4B		
							Handfinish - 1 - 9 - B4B		
							Handfinish - 1 - 10 - B4B		
							Handfinish - 1 - 11 - B4B		
							Handfinish - 1 - 12 - B4B		
							Handfinish - 1 - 13 - B4B		
							Handfinish - 1 - 14 - B4B		
							Handfinish - 1 - 15 - B4B		
							Handfinish - 1 - 16 - B4B		
							Handfinish - 1 - 17 - B4B		

**Container No:** S278340**Part:** D2596**Job No:** 209888**Serial No/Batch:** S278340**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
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Date: 05/19/20

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					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
120 QC 5	4 pcs	6/12/20	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	DAS
					QC 5 - 3	03
					QC 5 - 43	9-89
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					QC 5 - 82	
130 Packaging 3-1 - Stock - B4B	4 pcs	6/12/20	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	DAS
					Packaging 3 - 26 - B4B	03
					Packaging 3 - 27 - B4B	9-89
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	

5/13/2020

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
140 QC 21 - SA	4 pcs	6/12/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - 1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.630" diameter as per Descriptions: Dwg D2596 4- Deburr 110 - (Chemical Conversion Coat per QSI005 4.1) 120 - (QC5- Inspect part completeness to step on W/O) 130 - (Identify as per dwg & Stock Location: _____) 140 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D2500-3-100	Ext'n - I' Beam Web 4"	4 pcs (1 ea)	100-Skidtubes - 1	S166539	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Skidtubes - 1	D2500-3-100	4	96	0	
Part Specifications					
Specifications could not be found.					

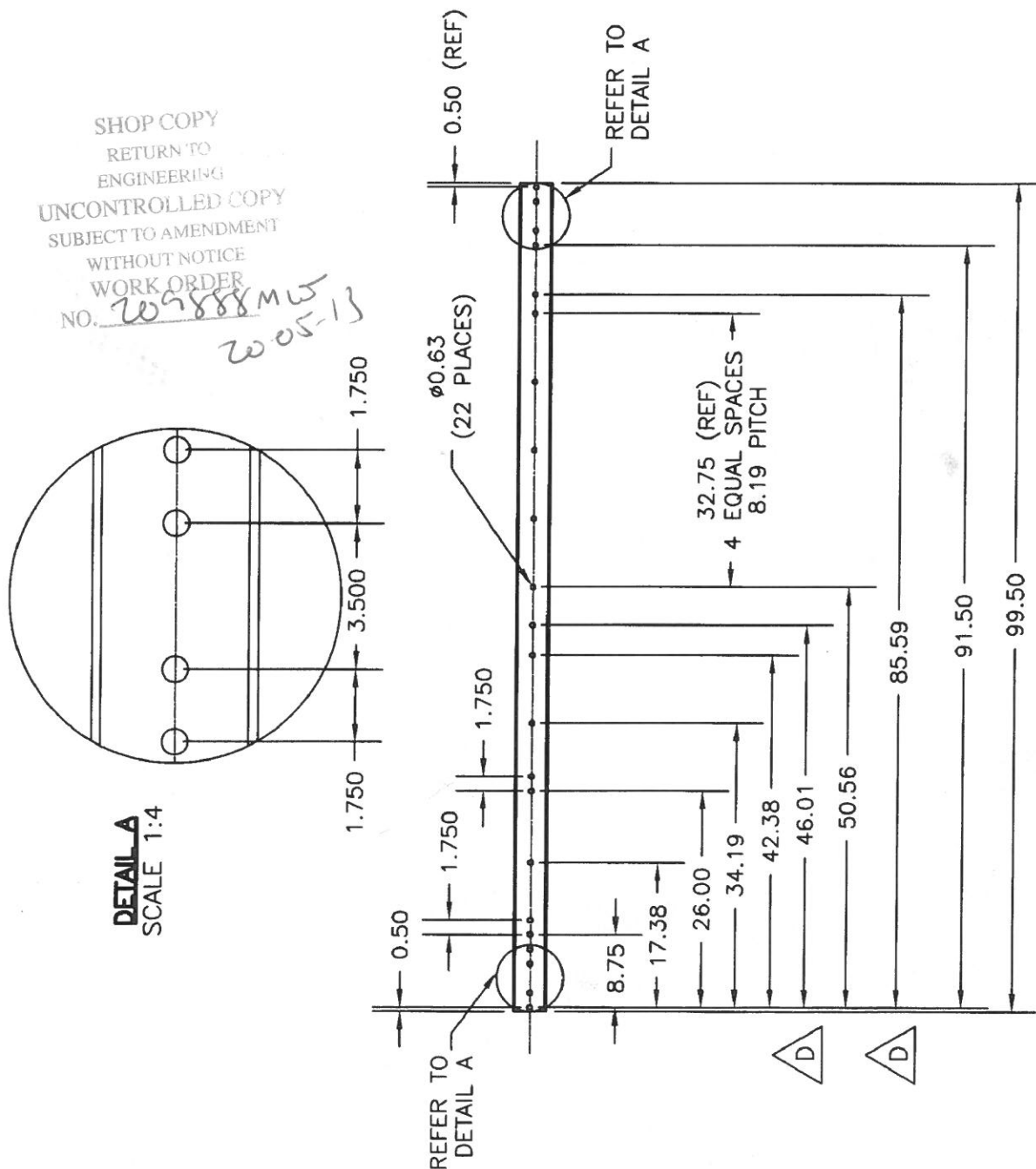
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RELEASED
07-06-28

DESIGN RH		DRAWN BY RH		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H		APPROVED H		DRAWING NO. D2596 REV. D SHEET 1 OF 1	
DATE 07.04.17		TITLE 205 WEB		SCALE 1:20	
A	96.09.16	NEW ISSUE			
B	97.07.23	ø0.63 HOLE WAS ø0.56			
C	98.09.14	INCORPORATED DEO 9097			
D	07.04.17	INCORPORATED DEO 9183			

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 209888M

DETAIL A
SCALE 1:4



- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION			DEPARTMENT/PROCESS																																																																																
		Rework Scrap Use-as-is			Skid-tube Machining Large Fab		Cross tube Small Fab Finishing		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging		Engineering Water Jet Supplier Quality																																																																										
Date :	Sequence #:	QTY Affected :		MRB (QS1042)																																																																																	
Description Work Order Deviation				Disposition																																																																																	
Root Cause <table border="1"><tr><td>Operator</td><td></td></tr><tr><td>Manufacturing Process</td><td></td></tr><tr><td>Equip/Tooling</td><td></td></tr><tr><td>Handling/Preservation</td><td></td></tr><tr><td>Material</td><td></td></tr><tr><td>Product Improvement</td><td></td></tr><tr><td>Process Improvement</td><td></td></tr><tr><td>Human Factors</td><td></td></tr></table>				Operator		Manufacturing Process		Equip/Tooling		Handling/Preservation		Material		Product Improvement		Process Improvement		Human Factors		FAULT CATEGORY <table border="1"><tr><td>Pressure/Forced</td><td></td><td>Contamination</td><td></td><td>Power Loss/Surge</td><td></td><td>Positioned Wrong</td><td></td></tr><tr><td>Bending</td><td></td><td>Misaligned/off center</td><td></td><td>Folio/Program</td><td></td><td>Outside Tolerance</td><td></td></tr><tr><td>Crushing</td><td></td><td>BOM/Route</td><td></td><td>Grain Direction</td><td></td><td>Drawing</td><td></td></tr><tr><td>Cracks</td><td></td><td>Broken/Damage/Defect</td><td></td><td>Weld</td><td></td><td>Finish</td><td></td></tr><tr><td>Crimp/Kink/Ripple/Wave/Twist</td><td></td><td>Incomplete/Unclear Instructions</td><td></td><td>Wrong Stock Pulled</td><td></td><td>Part Lost/Missing</td><td></td></tr><tr><td>Marks/Chatter</td><td></td><td>Drill Holes</td><td></td><td>Out of Sequence</td><td></td><td>Misread</td><td></td></tr><tr><td>Mislabeled</td><td></td><td>Fit/Function</td><td></td><td>Off-set/Set-up</td><td></td><td></td><td></td></tr></table>										Pressure/Forced		Contamination		Power Loss/Surge		Positioned Wrong		Bending		Misaligned/off center		Folio/Program		Outside Tolerance		Crushing		BOM/Route		Grain Direction		Drawing		Cracks		Broken/Damage/Defect		Weld		Finish		Crimp/Kink/Ripple/Wave/Twist		Incomplete/Unclear Instructions		Wrong Stock Pulled		Part Lost/Missing		Marks/Chatter		Drill Holes		Out of Sequence		Misread		Mislabeled		Fit/Function		Off-set/Set-up			
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Other/Details:																																																																																					
Completed By				Lead hand / Supervisor				QC / QA Coordinator																																																																													